

Date: Thursday, 2/1/2007 2:49:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HEATER EXTERIOR SHEET	
Job Number	: 30579		Part Number	: D2295	
Estimate Number	: 12691		Drawing Number	: D2295 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/1/2007		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/15/2007	
Previous Run			Qty:	4	
Written By			Um:	Each	
Checked & Approved By	: <u>4/02/01</u>				
Comment	: Est Rev:A New Issue 07-02-01 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S032	6061-T6 Sheet 0.032"
		
	Comment: Qty.: 2.6250 sf(s)/Unit Total : 10.5000 sf(s) 6061-T6 Sheet 0.032" Batch: <u>M18375</u>	FF 07-03-06
2.0	WATERJET SMALL FAB.	FLOW WATER JET
	Comment: <u>FLOW WATER JET</u> SHARP 1- as per Dwg D2295 Dwg Rev: _____ Prog Rev: _____ 2- Drill as per Template T2295 DS. 3- Deburr if necessary	FF 07-03-06
3.0	QC & QCS	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	07/02/12 4
4.0	QC N/A	SECOND CHECK
	Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<u>07/03/13 06</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

207103/17

Job Completion



U 070314

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

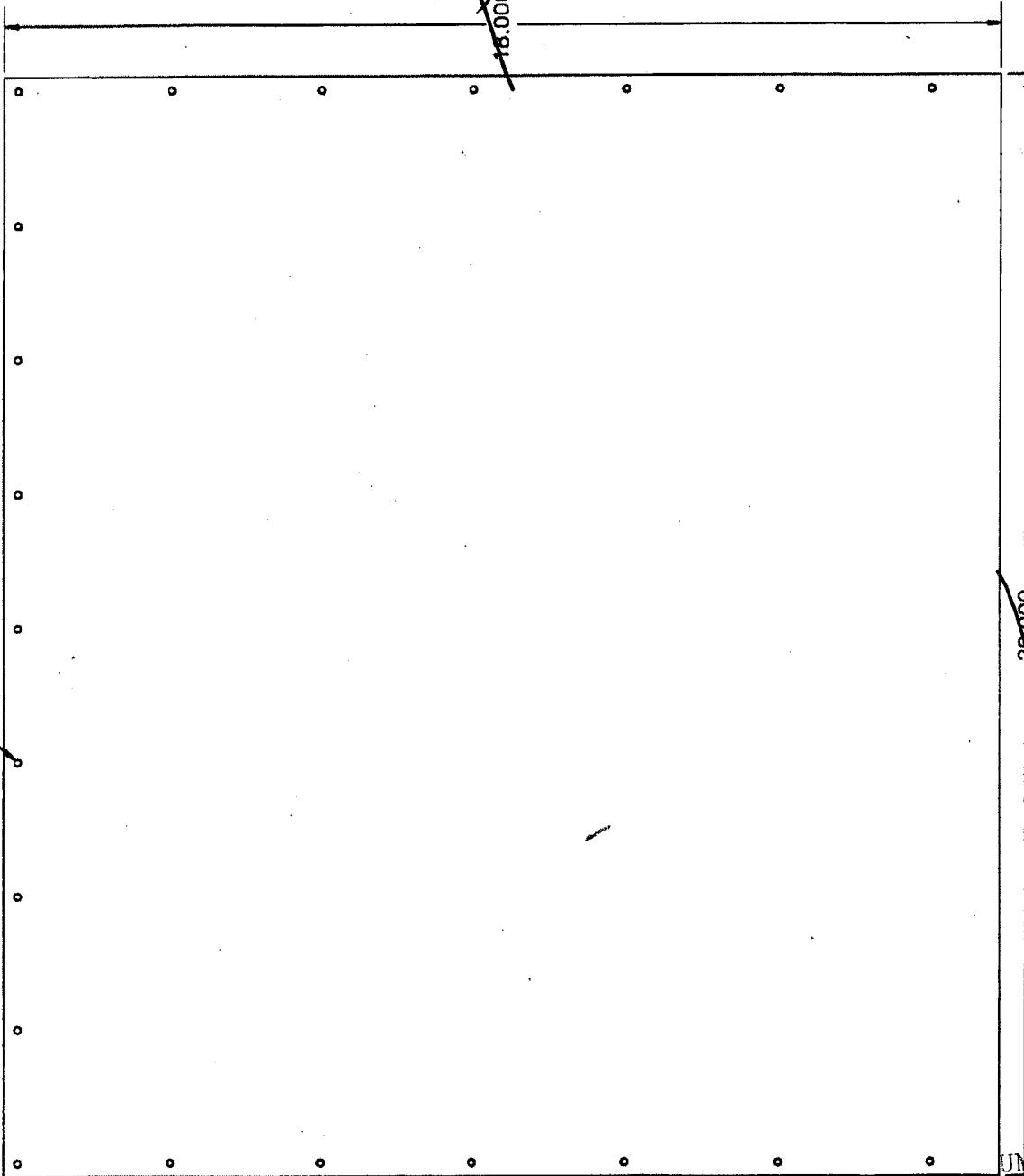
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED Paw	APPROVED B.W.	DRAWING NO. D2295	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE HEATER EXTERIOR SHEET	SCALE 1:3
B	96.01.15	DEFINE HOLES	

Φ0.128 DRILL PER TEMPLATE T2295DJ



20.000
16.000
07.03.12
01.01.12
MATERIAL: 6061-T6 OR 5052-H34 SHEET 12
0.032 THICK CUT 18 X 20

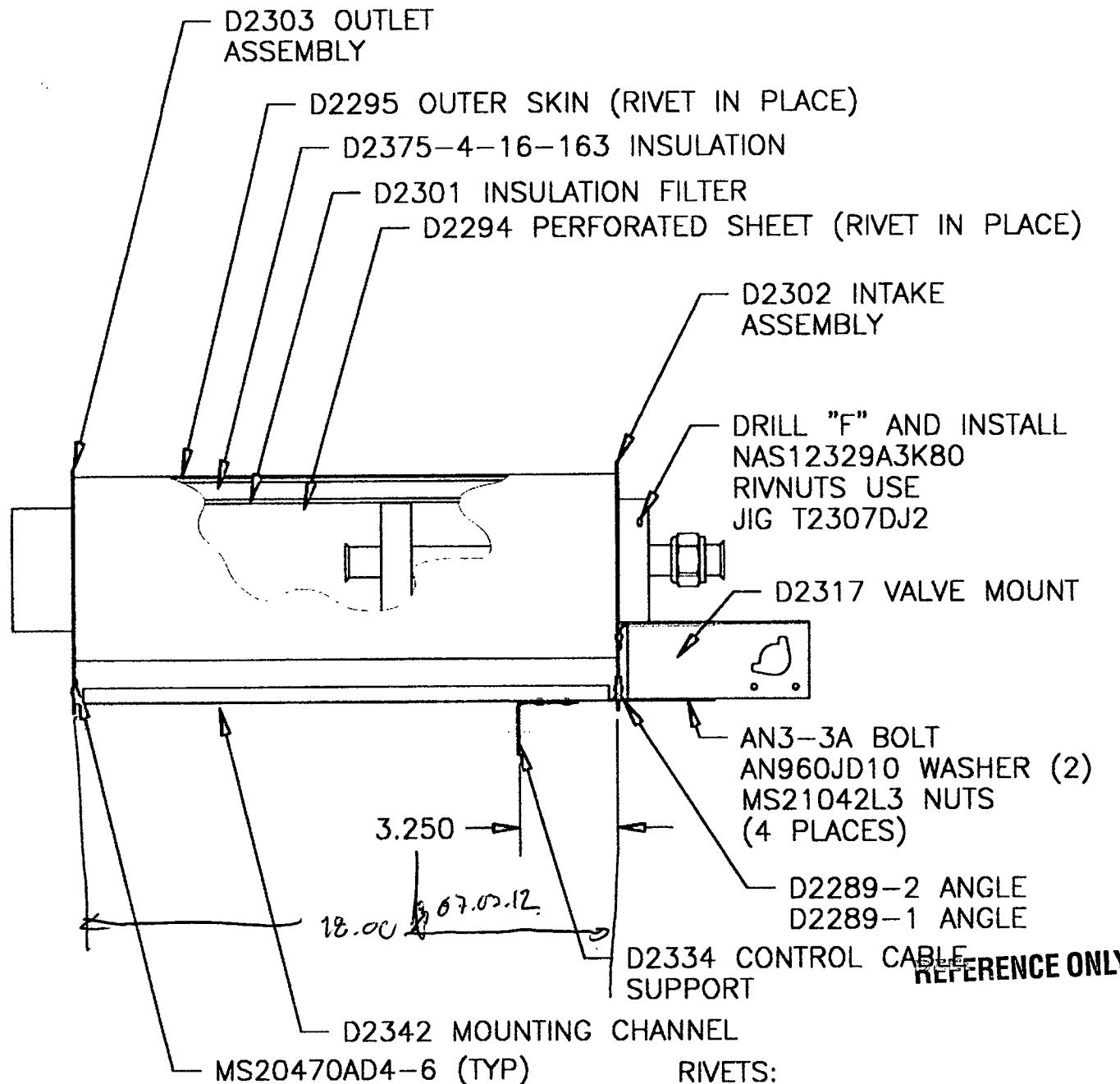
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30579

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS		
CHECKED	APPROVED	DRAWING NO.	REV. C
B	B	D2306	SHEET 1 OF 2
DATE	TITLE		SCALE
95.01.03	B204 ASPIRATOR ASSEMBLY		
B	Apr. 13, 1995	REVISED D2317	
C	96.01.19	ADDED DETAIL	

QTY	Part No.	Description
X	D2306	B204 ASPIRATOR ASSEMBLY
1	D2302	INTAKE WELDMENT ASSEMBLY
1	D2303	OUTLET WELDMENT ASSEMBLY
1	D2295	HEATER EXTERIOR SHEET
1	D2375-4-16-163	INSULATION
1	D2301	INSULATION FILTER
1	D2294	HEATER PERFORATED SHEET
1	D2289-1	VALVE MOUNTING BRACKET
1	D2289-2	VALVE MOUNTING BRACKET
1	D2317	VALVE MOUNTING BRACKET
1	D2334	CONTROL CABLE SUPPORT
1	D2342	MOUNTING CHANNEL
4	AN3-3A	BOLT
8	AN960JD10	WASHER
7	MS20600AD4W5	RIVETS CR9163-4-2
23	MS20600AD4W6	RIVETS CR9163-4-4
6	MS20470AD4-6	RIVETS
4	MS21042L3	NUTS
2	NAS1329A3K80	RIVNUTS

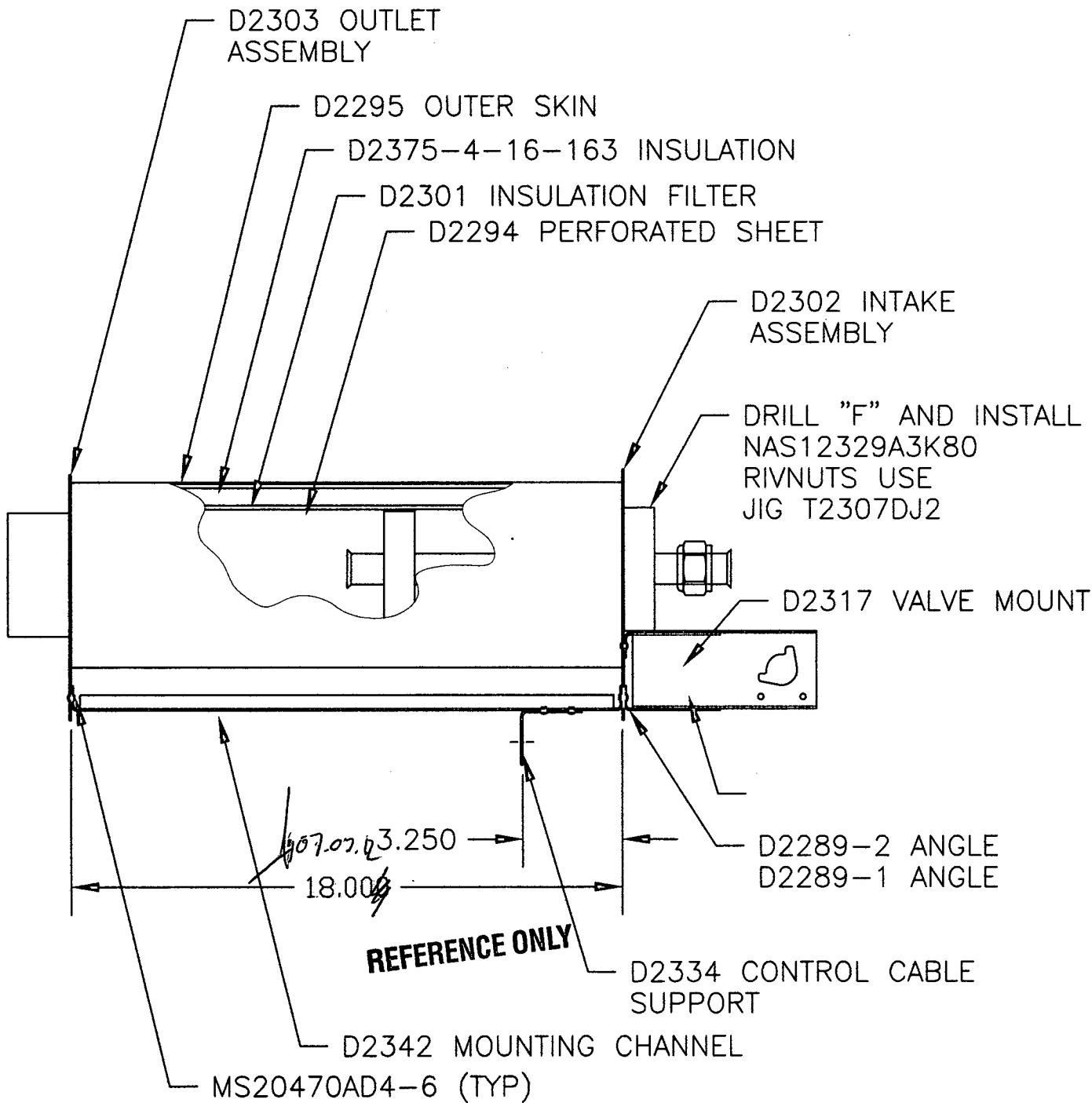
REFERENCE ONLY



DART

COPIED
BY
CJO

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B	B. WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
B	B	D2306	
DATE	95.01.03	TITLE	B204 ASPIRATOR ASSEMBLY
		SCALE	



DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	REV. C
DATE 95.01.03	DRAWING NO. D2306	SHEET 2 OF 2
B	TITLE B204 ASPIRATOR ASSEMBLY	SCALE
C	96.01.19	ADDED DETAIL